

Date: Monday, 1/8/2007 10:53:15 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER ASSEMBLY
Job Number	: 30158C		
Estimate Number	: 10295	Part Number	: D3220042
P.O. Number	: <i>N/A</i>	Drawing Number	: D3220 REV A1
This Issue	: 1/8/2007 S.O. No. : <i>N/A</i>	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A1
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Material	: <i>N/A</i>
Previous Run	: 29382C	Due Date	: 1/30/2007 Qty: 6 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 07.01.08		
Comment	: Est Rev: A New Issue 05-11-06 JLM Est: B 06.11.15 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.7266 sf(s)/Unit Total : 4.3596 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050
 Identify for D3220-2
 Batch: *H103210*

SAD 07/01/20 (6)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut D3220-1 as per Dwg D3220
 Dwg Rev: *A1*
 Prog Rev: *A1*

2-Deburr if necessary

SAD 07/01/20 (6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/01/20 (6)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAD 07/01/22 (6)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07/01/20 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:53:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Darl Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 30158C

Part Number: D3220042

Job Number:



Séq. #:

Machine Or Operation:

Description :

2-C'sink D3220-2 as per Dwg D3220

ml 07/01/05

6.0

QC5

INSPECT WORK TO CURRENT STEP



207-0125



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

221 K

07-01-39 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/02/06

x6

9.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS20426AD3-4

Rivet

m 102404

✓

10.0

MS21059L4

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21059L4

Nutplate

m 102959

✓

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3220-042 doubler as per Dwg D3220

ml 07/02/06

12.0

QC5

INSPECT WORK TO CURRENT STEP



207-0086



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:53:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 30158C

Part Number: D3220042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5193*

Boz/02/09 (6)

PC

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

Boz/02/12

Job Completion



11 270209

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

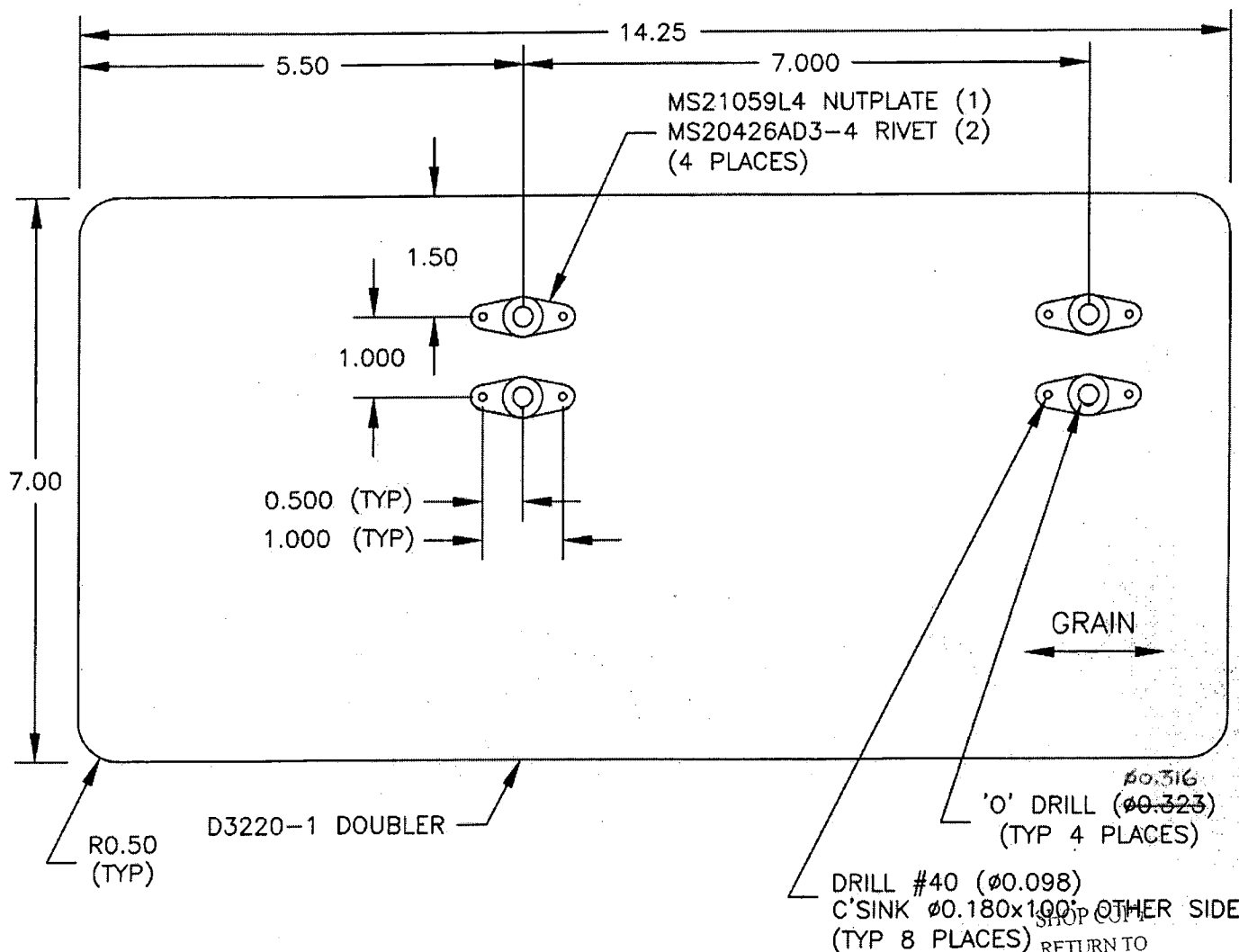
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>#</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3220 REV. A SHEET 1 OF 2
DATE	03.10.16	TITLE	DOUBLER	SCALE 1:2
A	03.10.16	NEW ISSUE		
A1	<i>CP</i> 03.11.13	CORRECTED DIM.		

RELEASED
03.11.14 *#*



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30158C*

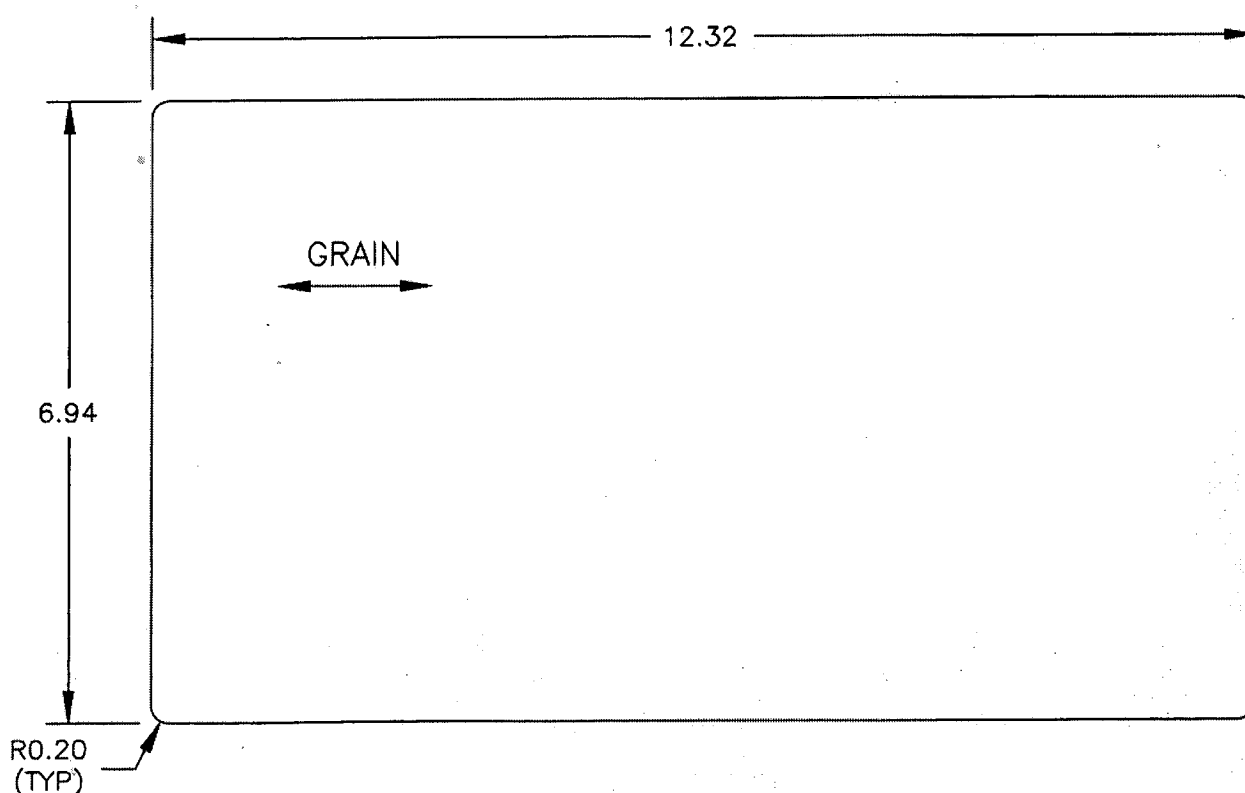
Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED
03.11.14 *[Signature]*



D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *301582*

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order:	30158B
Description:		Part Number:	D3220 041
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

x	First Article
----------	----------------------

x	Prototype
1	1
2	2
3	3
4	4
5	5
6	6
7	7
8	8
9	9
10	10
11	11
12	12
13	13
14	14
15	15
16	16
17	17
18	18
19	19
20	20
21	21
22	22
23	23
24	24
25	25
26	26
27	27
28	28
29	29
30	30
31	31
32	32
33	33
34	34
35	35
36	36
37	37
38	38
39	39
40	40
41	41
42	42
43	43
44	44
45	45
46	46
47	47
48	48
49	49
50	50
51	51
52	52
53	53
54	54
55	55
56	56
57	57
58	58
59	59
60	60
61	61
62	62
63	63
64	64
65	65
66	66
67	67
68	68
69	69
70	70
71	71
72	72
73	73
74	74
75	75
76	76
77	77
78	78
79	79
80	80
81	81
82	82
83	83
84	84
85	85
86	86
87	87
88	88
89	89
90	90
91	91
92	92
93	93
94	94
95	95
96	96
97	97
98	98
99	99
100	100

[illegible]

Measured by: <i>SAN</i>	Audited by:	Prototype Approval:
Date: <i>07/01/20</i>	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	